

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009209**Date Inspected:** 22-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Yumin Xu**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG and Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Larry Viars was present during the times noted above for observations relative to the work being performed.

OBG Trial Assembly-

This Quality Control Inspector observed ZMPC personnel performing the following work: Shielded Metal Arc Welding of OBG segment 1AAE bottom panel base material adjacent to 1AAE to 1AE transverse Splice weld OBE1A-003. The welder was identified as 050316. ZPMC QC was identified as Yumin Xu. The welding procedure specification listed on the Weld repair report WR 7764 was WPS-345-SMAW-1G (1F)- Repair.

QA observed ZPMC grit blasting OBG segment 4BW interior surface of side panels.

Bay 10-

This QA Inspector observed the following work in progress: FCAW welding of South Tower Lift 4 diaphragm to Skin Plate A partial joint Penetration weld SSTL4-1 C/L-49. ZPMC welder was identified as 053116. ZPMC QC is identified as Li Ming. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-4332-TC-P5-F.

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WELDING INSPECTION REPORT

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This QA Inspector observed the following work in progress: SAW welding of Bottom panel BP109A to BP55A butt splice weld SEG073A-005. ZPMC welder was identified as 062406. ZPMC QC is identified as Lv Li Qing. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2221-L-L2c-S-2.

This QA Inspector observed the following work in progress: FCAW welding of OBG segment 9CW lower floor beam to bottom panel fillet welds SSD10-PP80-070 through 089. ZPMC welder was identified as 062406. ZPMC QC is identified as Lv Li Qing. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2132.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation between QC and QA occurred this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150 0042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
